

Work Order ID 48086

June 26, 2009 11:03:14 AM



Page 1

Item ID: D3391-023
Revision ID: H
Item Name: Mid Tube Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 1.00
Required Date: 03/08/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:

SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H

100

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Cut tube to finish length as per Dwg D3391 12-Identify as D3391-023 13-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391 14-Open saddles and GHW holes to Ø0.375" except for fwd saddle



110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control



120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing



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Page 4

Item ID: D3391-023
Revision ID: H
Item Name: Mid Tube Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 1.00
Required Date: 03/08/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

09-07-10

①

BK

210



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1- insert D3391-021 into D3391-23; 2- insert T-pins into first and third fwd saddle holes 3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DS1 9364; 4- remove T-pins and locate DT9415 from first and third crossbolt hole using

UMP 09/07/10

Work Order ID 48086

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Page 5

Item ID: D3391-023
Revision ID: H
Item Name: Mid Tube Assembly

Accept

Setup Start
Stop

Start Date: 15/07/2009 Start Qty: 1.00
Required Date: 03/08/2009 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> 5060810

230



HandFinish

Hand Finishing

HandFinishing

Memo

Install Inserts as per Dwg

0.00

0.00

✓

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

✓

Work Order ID 48086

June 26, 2009 11:03:15 AM



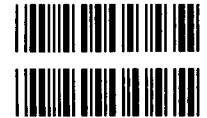
Page 6

Item ID: D3391-023
Revision ID: H
Item Name: Mid Tube Assembly

Accept



Setup Start
Stop



Start Date: 15/07/2009 Start Qty: 1.00
Required Date: 03/08/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PP

51414

9/9/11 54 R

09/09/03

09-9-02

Picklist Print

July 1, 2009 10:31:57 AM

Page 1/1

Work Order ID: 48086

Parent Item: D3391-023RevH

Parent Item Name: Mid Tube Assembly


Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ ALS4-1032-130		Purchased	No			100	Each	7,849.000	22.0000			
<div>  </div>												
Insert												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

110511

UMB

09/07/09

7849

7849

140

Each

0.0000

1.0000

✓ D3391-021RevH

Manufactured

No

Fwd Tube Assembly

✓ D3591-1RevB

Manufactured

No

Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43172

46105

47121

79

6

29

44

UMB 09/07/09

Date: Wednesday, 20/05/2009 1:10:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MID TUBE ASSEMBLY
Job Number : 48086	
Estimate Number : 10469	
P.O. Number :	Part Number : D3391023
This Issue : 20/05/2009 S.O. No. :	Drawing Number : D3391 REV H
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SKIDTUBES	Drawing Revision : H
Previous Run : 48085	Material :
Written By :	Due Date : 29/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.05.20</u>	
Comment :	
Est. A 05.10.20 New Issue KJ/EC	
Est. B 06.02.10 ECN773 dwg rev.D EC	
est C 07.03.20 rev F dwg EC	
est D 07.03.28 re-format EC	
est E 07.10.31 ecn 1053P EC	
Est Rev:F ECN 1056 07-11-13 DD verified by: EC	
Est Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC	
Est Rev:H 08-09-10 revH as per dwg DD verified by:EC	
Est Rev:I 08-11-13 Removed steps per w/o, QC KJ verified by: ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description
1	D2500-1-100	Extrusion

Batch

B- 24593

AWM 9-5-21

(1)

2.0	D3391021	Fwd Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch: B47305

(1)

H 9-6-2

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as

AWM 9-5-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:10:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48086

Part Number: D3391023

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

11-Open .375" holes to .438" ***do not open fwd saddle holes***

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up - previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drill remaining 6 wearplate holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sort 6/03 (E)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:10:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48086

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pm 09-06-07



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① 19-6-4

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

B47363

A/R

Sikaflex-241/-291

M11557

Sikaflex expire date:

10-01-20

Start: *09-06-07* Time: *3:00 pm*

Finish: _____ Time: _____

Pm 09-06-07

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open float bag holes to 0.313"

2-C'sink float bag holes as per dwg

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

Pm 09-06-07

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LE 09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:10:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48086

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D36811

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

SPACER

batch: B47123

Imc 09-06-05

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld crossbolt spacer as per dwg D3391 & QSI 004

2-grind weld flush

Imc 09-06-08

2E 09-06-08 AIR M111679

12.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8 09/06/08 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/06/08 (4)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M111472
Pressure Wash

UMP 09/06/10 (4)

START TIME:

1:30pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:00pm

off 09-06-11 (4)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-07-10 (1)

16.0

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

B 43172

UMP 09/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:10:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48086

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

umd 09/07/10

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/12

19.0

ALS41032130

Insert



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

INSERT

batch: m110511

or equivalent

per QSI 017

umd 01/10/10

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

umd 09/07/10

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:10:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48086

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

23.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



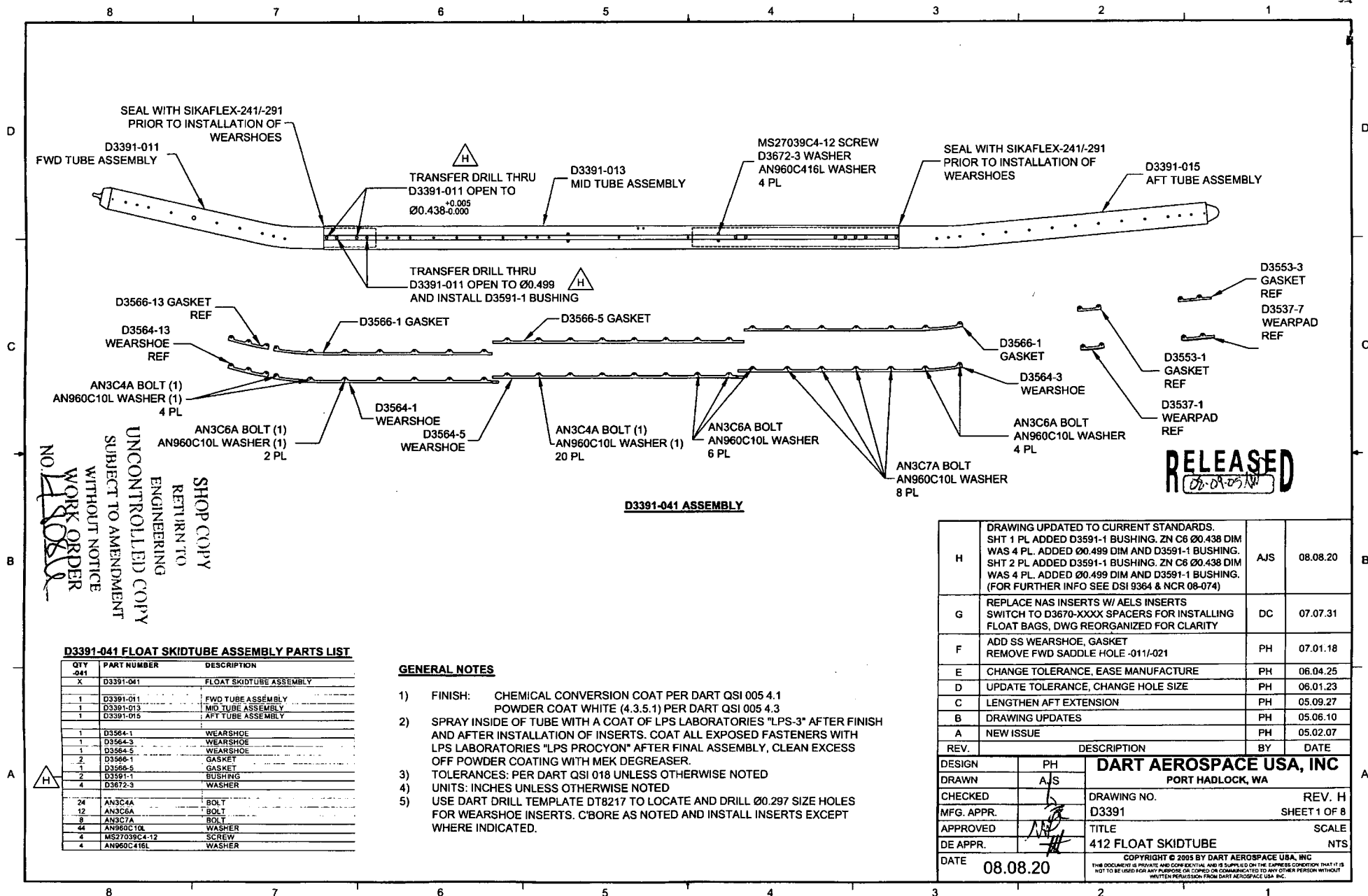
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

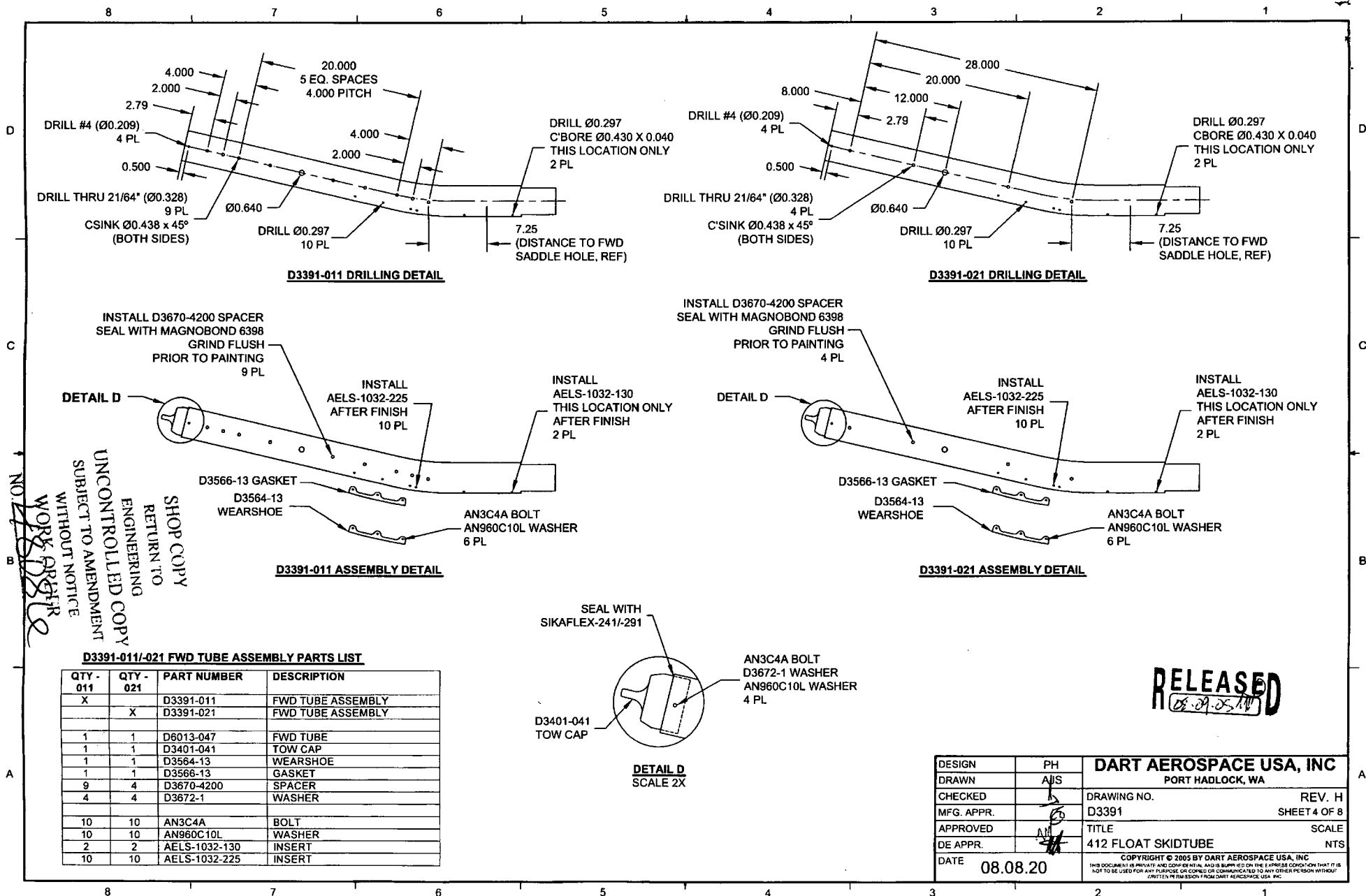
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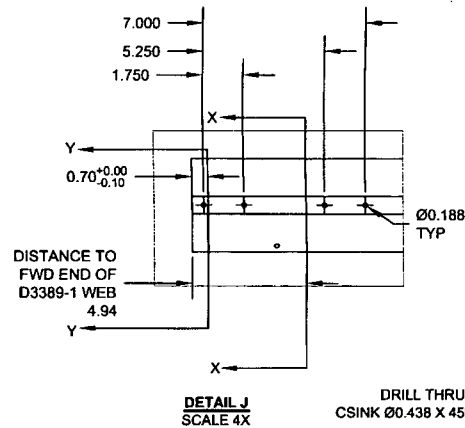
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

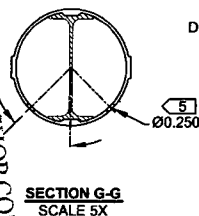
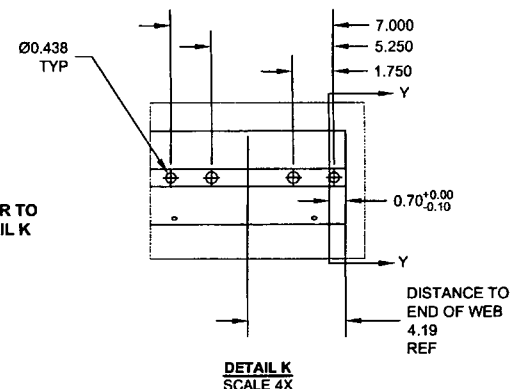
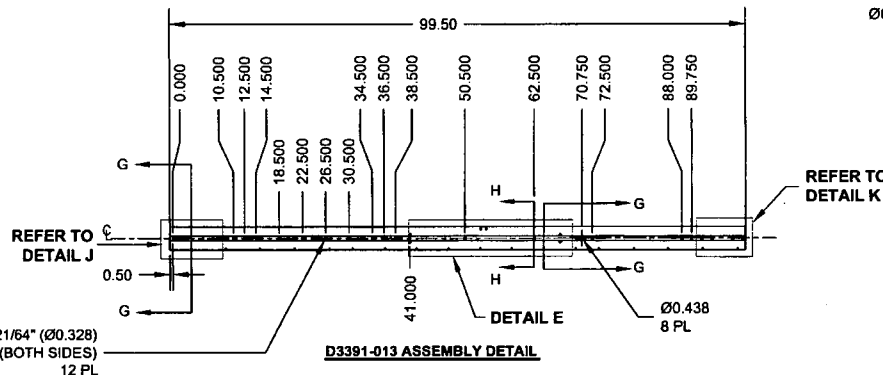
NOTE: Date & initial all entries



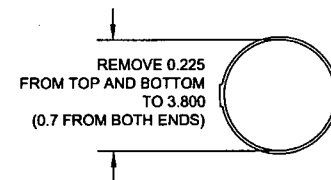
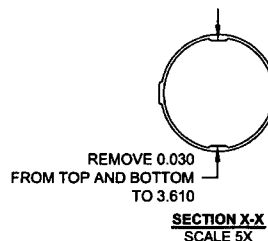
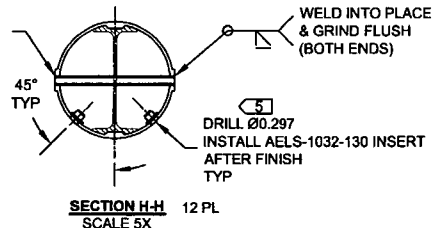




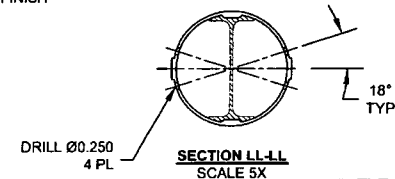
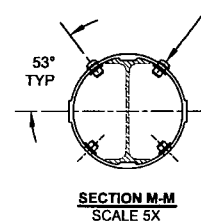
DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



INSTALL
D3681-1 SPACER



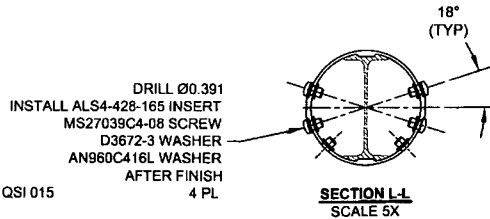
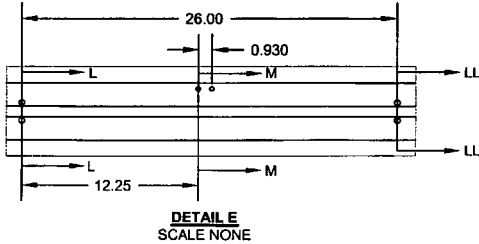
DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



RELEASED

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

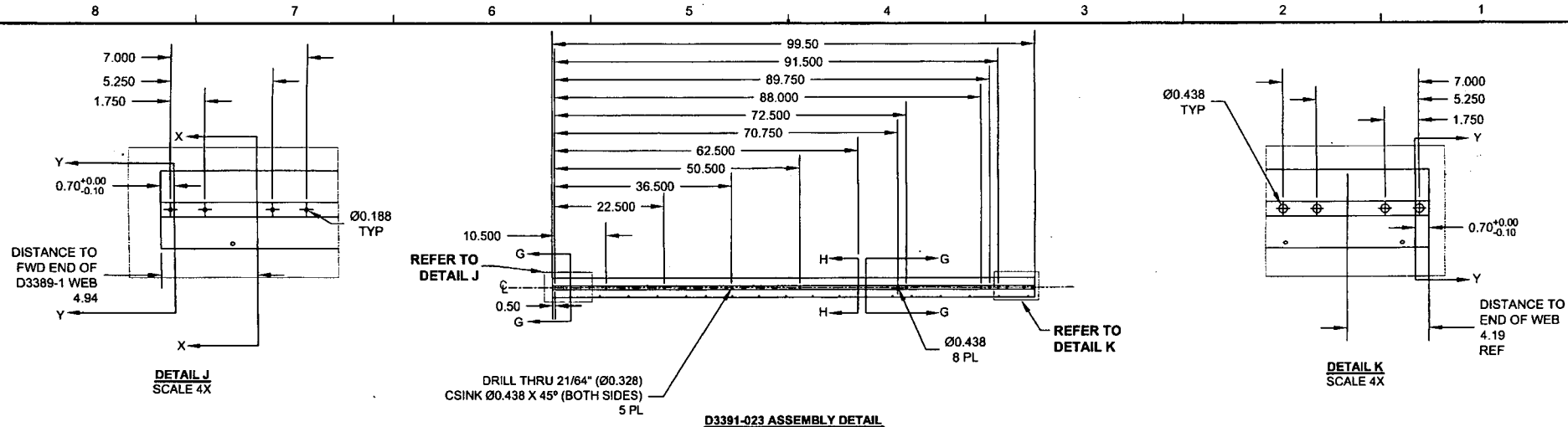


D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

WORK ORDER
NO. 180872



DETAIL J
SCALE 4X

DETAIL K
SCALE 4X

D3391-023 ASSEMBLY DETAIL

SECTION G-G
SCALE 5X

SECTION H-H
SCALE 5X

SECTION X-X
SCALE 5X

SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

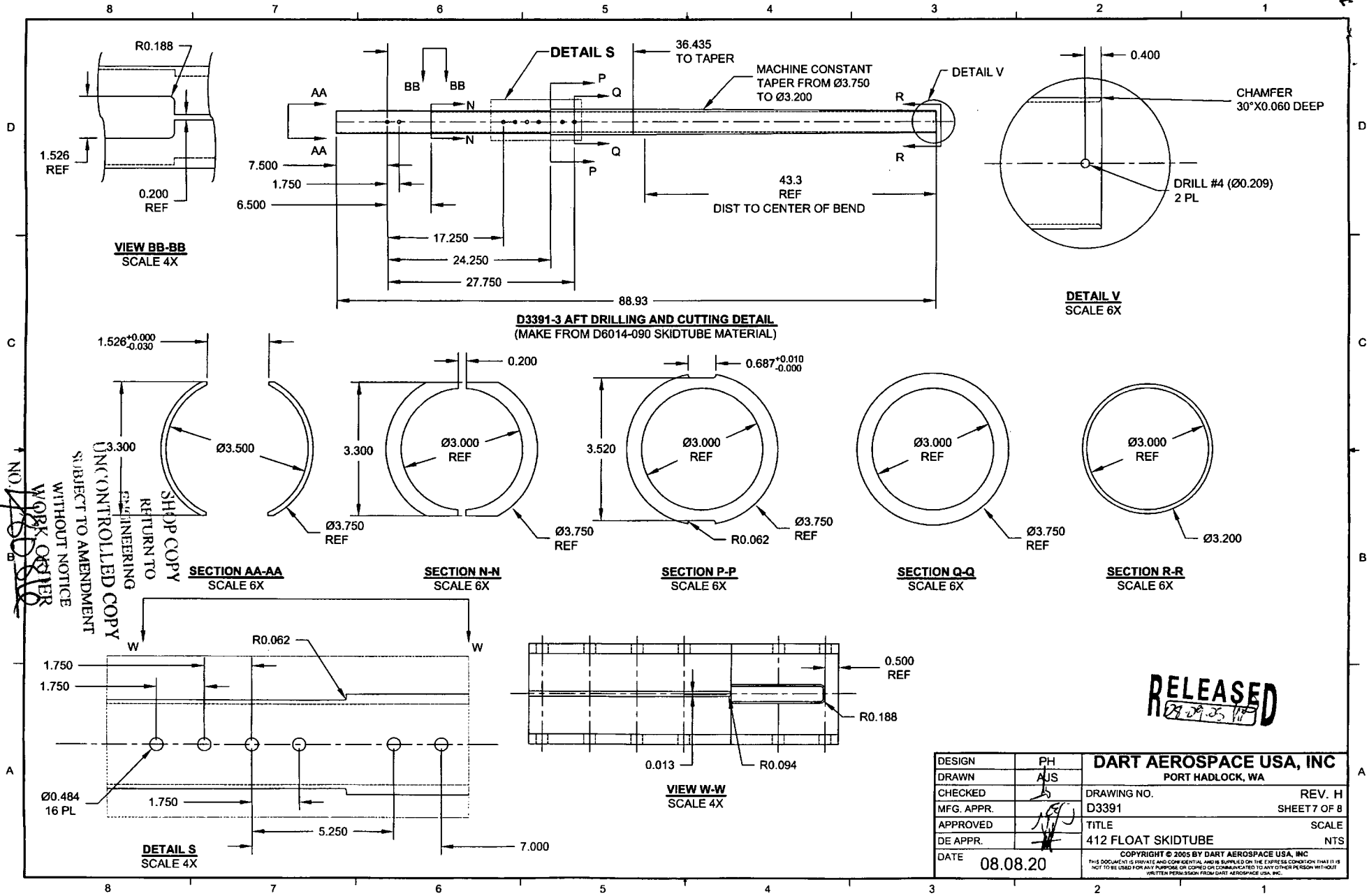
QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

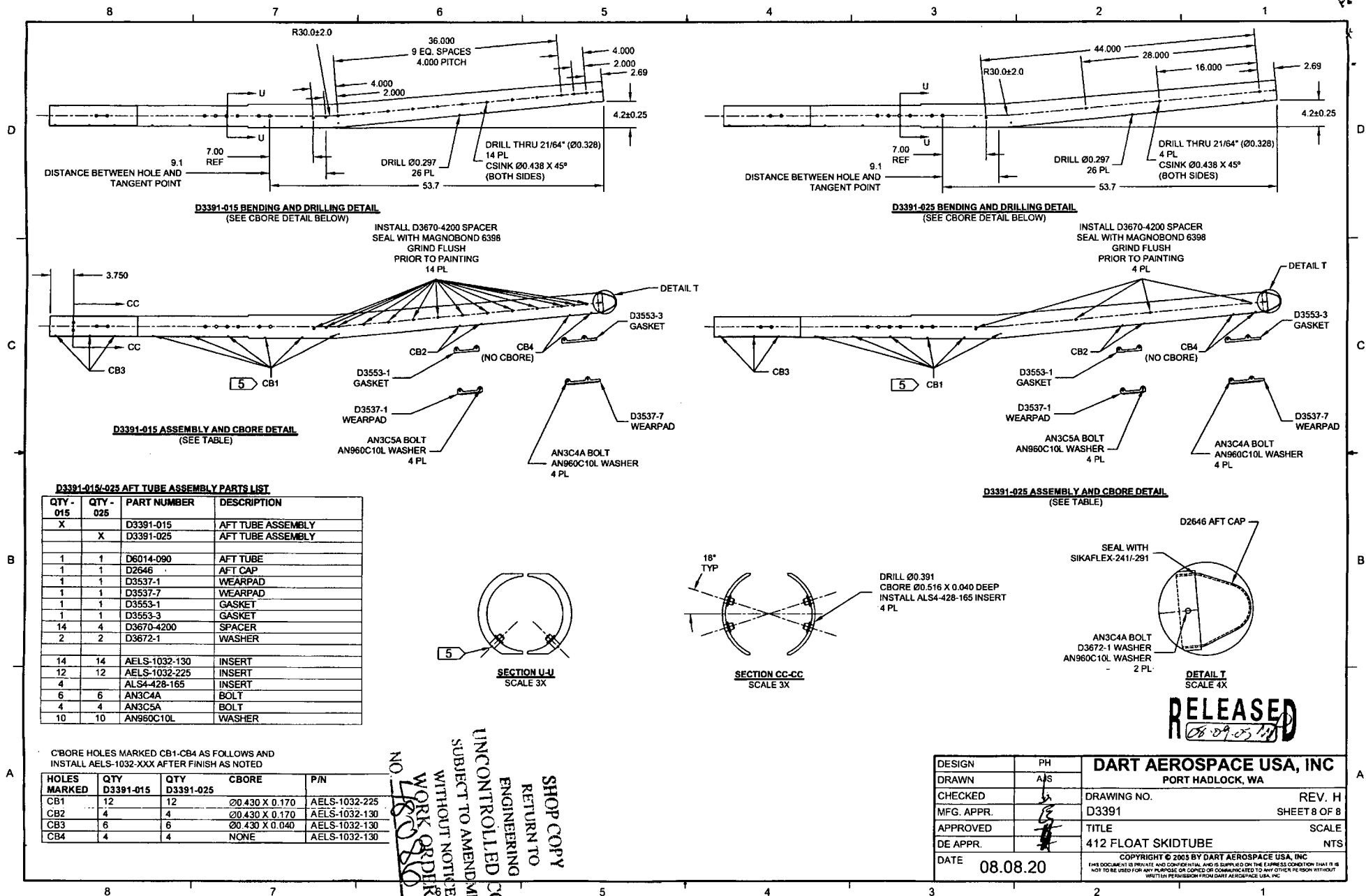
RELEASED
08-05-17

DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AS		
CHECKED	5	DRAWING NO.	REV. H
MFG. APPR.	5	D3391	SHEET 6 OF 8
APPROVED	5	TITLE	SCALE
DE APPR.	5	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

WORK OF
 NO. 480882
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NO. 1750
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
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ENGINEERING
RETURN TO
SHOP COPY
1.526^{+0.000}_{-0.030}
3.300
Ø3.500
Ø3.750 REF
Ø3.000 REF
Ø3.750 REF
Ø3.000 REF
Ø3.750 REF
Ø3.000 REF
Ø3.750 REF
Ø3.000 REF
Ø3.200



NO. 200

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 48045
Part number: D3391 023
Description: Mid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Vol. 1

Date of Test Coupon 09-06-01

Welder Barclay Elliott

Date of Test Coupon 09-06-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld